

DART AEROSPACE LTD		Work Order:	22254
Description: Base Plate		Part Number:	D3333-1
Dwg: D3333 Rev. A PAGE 1		Qty:	10
		Page 1 of 1	

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	HA	05.01.17	10
2	MV	Cut blanks: 4.000" x 0.750" thick x 9.00" long Material: AISI 4140 Steel Bar (M4140N-B0.750x04.000) Identify for D3333-1 Batch: M16700	WZ	05.02.16	10
3	MV	Machine as per Folio FA478 and Dwg D3333 Identify as D3333-1	BE	05.02.09	10
4	QC2	Inspect parts as they come off the CNC machine	BE	05.02.09	10
5	MV	Tap holes as per Dwg D3333	CPL	05.02.09	10
6	QC8	Second check	MA	05.02.09	10
7	MV	Deburr	CPL	05.02.09	10
8	FP	Powder Coat Fire Red (Ref. 4.3.5.10) as per QSI 005 4.3 Ensure to mask threaded holes	MM	05.02.16	10
9	QC3	Inspect Powder Coat	W	05.02.18	10
10	ST	Identify and Stock	W	05.02.18	10
11	AC	Cost / part: 67.18	SAC	05.02.21	10
12	DC	Close W/O 67.18 Inspect Level 21	HA	05.02.23	10

Rev	Date	Change	Revised By	Approved
A	05.01.13	New issue	KJ/JLM	

RELEASED
05.01.17

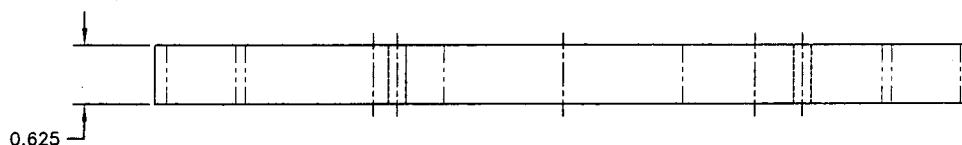
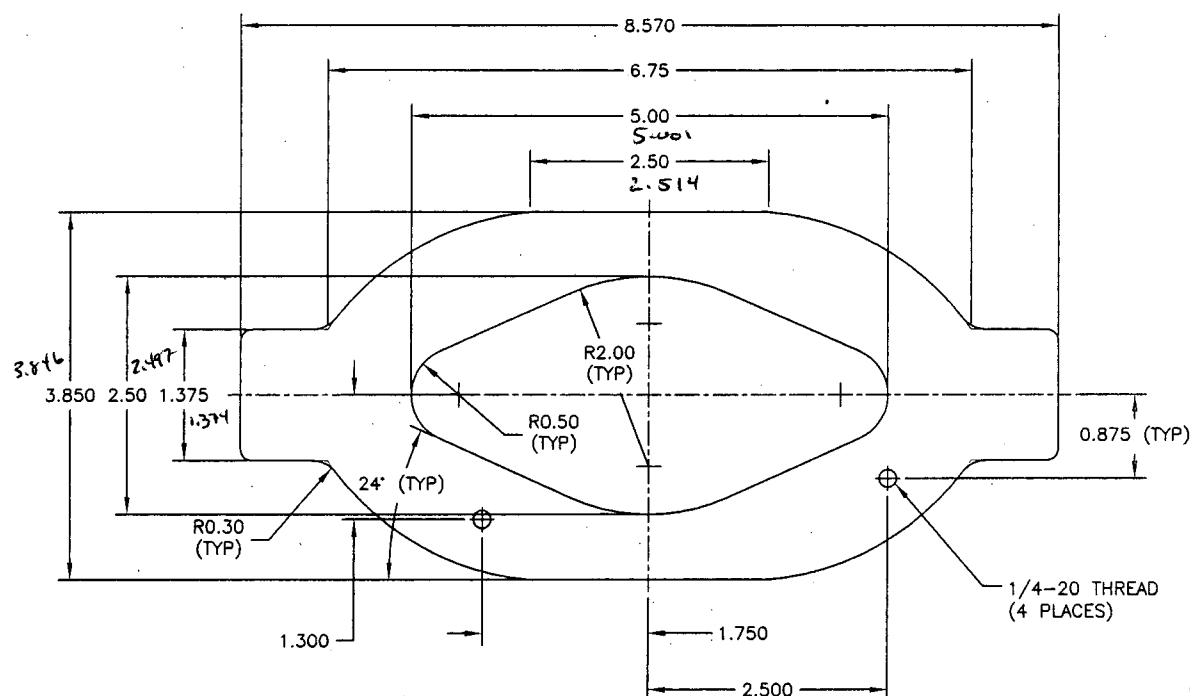
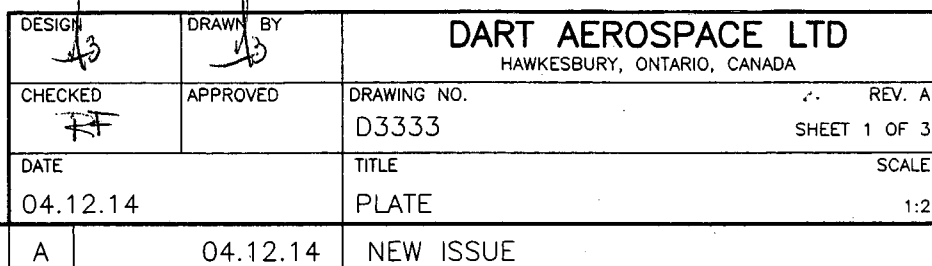
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____



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WITHOUT NOTICE

WORK ORDER

NO. 22254

D3333-1 BASE PLATE PANEL

NOTES:

- 1) MATERIAL: AISI 4140 STEEL 0.625 THICK STEEL (REF. DART SPEC. M4140-B)
MIN. YIELD TENSILE STRENGTH = 100 ksi
- 2) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- PRELIMINARY**

PRELIMINARY ISSUE

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Jan 17, 2005
01:31 pm

Work Order No : 0022254
Project Name : D3333-1
Project For :
Work Order Type : Main
Main WO Number :
House Part Number : D3333-1
Description : Base Plate
Manufactured : Yes
Amount Req'd : 10
Amount Done : 0
Start Date : 01-17-05
Est Finish Date :
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Margin : 0.000%
Actual Margin : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

